

Work Order ID 58906

May 19, 2010 1:17:46 PM



Page 1

Item ID: D3791-1

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 5/19/10 Start Qty: 12.00



Cust Item ID:

Required Date: 5/28/10 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3791	Rev A

100 0.00



FLOW WATER JET

Waterjet

Memo

0.00

10-5-25

FLOW CNC Waterjet

304 .063

1-Cut as per Dwg D3791

Dwg Rev: AProg Rev: A

2-Deburr if necessary

(16)

110 0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

10-5-25

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC8- Inspect parts - second check

0.00

S 100512C

X16

QC

Quality Control

130



NC BRAKE

0.00

16

Brake NC

Brake NC

Memo

0.00

1-Deburr if necessary

S 100512B

2-Form on Brake as per Dwg D3791 using Jigs

140



QC5- Inspect part completeness to step on W/O

0.00

X16

QC

Quality Control

Memo

0.00

Ensure joggle as per dwg D3429

S 100512Z

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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May 19, 2010 1:17:47 PM



Page 3

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Start Qty: 12.00



Cust Item ID:

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Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID****Operation
Description**Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Large Fab

0.00

02 10-6-7 216

Large Fab

Memo

0.00

1-Weld hardcoat as per dwg D3791 QSI004

Hardcoat 2059b Batch: M114642

160



QC10- Inspect visual per QSI004- ground welds

0.00

S1066101

QC

Memo

0.00

(X16)

170



QC5- Inspect part completeness to step on W/O

0.00

S1066101

QC

Memo

0.00

(X16)

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58906

May 19, 2010 1:17:47 PM



Page 4

Item ID: D3791-1

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Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 5/19/10

Start Qty: 12.00



Cust Item ID:

Required Date: 5/28/10

Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

180



Powdercoat

Powder Coating

Operation
Description

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

M112589

Memo

START TIME: 8:30 AM

OVEN TEMPERATURE: 320°C

FINISH TIME: 5:00 PM

190



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

16 BK 10-6-3.

200



Packaging

Packaging

Identify as per dwg & Stock Location: FP-17

0.00

0.00

M 10/04/03

16 0/

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 5

May 19, 2010 1:17:47 PM

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Start Date: 5/19/10 Start Qty: 12.00



Cust Item ID:

Required Date: 5/28/10 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

210

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Draw
Number

Rev.

Draw
Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
StampQC
Quality Control

Memo

0.00

10/06/04

PS10-6-03
(16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

May 19, 2010 1:17:45 PM

Work Order ID: 58906



Parent Item: D3791-1



Parent Item Name: Wearplate

Start Date: 5/19/10

Required Date: 5/28/10

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC
IPP Rev:B 08-05-22 revA as per dwg ECN1191 DD verified by:EC

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	65.3548	0.2917	4.7	2010-05-25	

304/316 Sheet .063

Location	Loc Qty	Loc Code
MAT	65.3548	
111323	0	
114467	65.3548	114467

(16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
1								

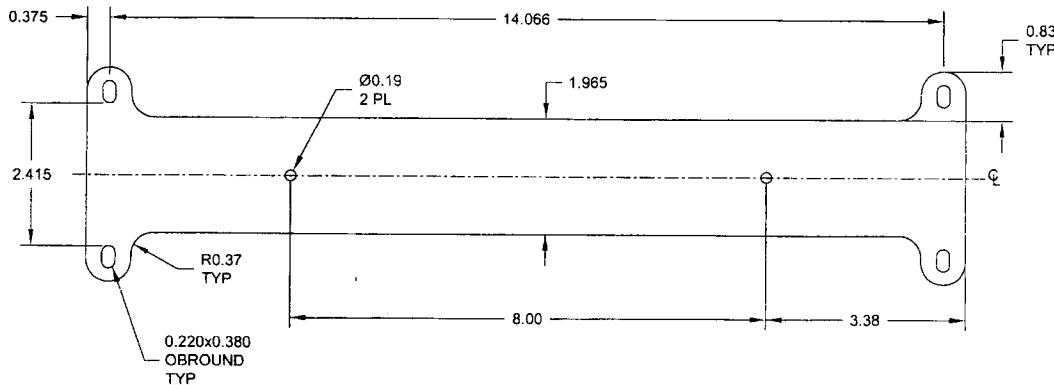
NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	<i>58400</i>
Description: Wearplate	Part Number:	D3791-1
Inspection Dwg: D3791 Rev: A		Page 1 of 1

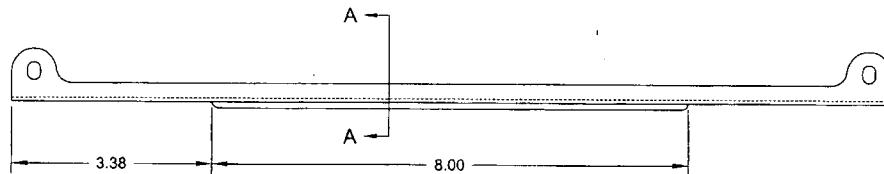
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

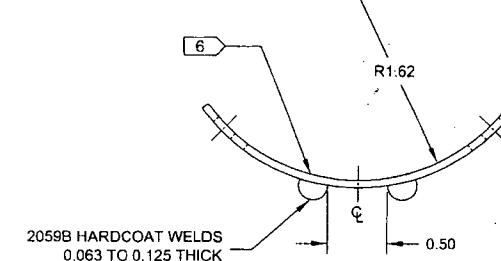
Measured by:	12	Audited by:	12	Prototype Approval:	N/A
Date:	10-5-25	Date:	10/05/26	Date:	N/A
Rev	Date	Change		Revised by	Approved
A	08.05.30	New Issue		KJ/DD	12



D3791-1F FLAT PATTERN



D3791-1 WEARPLATE
(MAKE FROM D3791-1F)



SECTION A-A
SCALE 2X

WB 58906

RELEASED
08.05.21/10

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF. DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3791-1" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: 0.70 LBS
- 8) WELD PER DART QSI 004

A	NEW ISSUE	PH	08.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3791	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
DATE	08.05.13	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC	

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